

Date: Thursday, 06/11/2008 2:25:13 PM  
 User: Julie Dawson











## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARSHOE
<b>Job Number</b>	: 43229		
<b>Estimate Number</b>	: 12787		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D35647
<b>This Issue</b>	: 06/11/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3564 REV D
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 33803	<b>Drawing Revision</b>	: D
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 17/11/2008
<b>Checked &amp; Approved By</b>	: <u>JUD 08-11-06</u>	<b>Qty:</b>	12 Um: Each
<b>Comment</b>	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
 		
<b>Comment:</b> Qty.: 0.8306 sf(s)/Unit Total : 9.9666 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>109057</u> <u>HB 8-11-11</u>		
2.0	WATER JET	FLOW WATER JET
 		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: <u>D</u> <u>HB 8-11-11</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>HB 8-11-11</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 		
<b>Comment:</b> SECOND CHECK <u>06-11-12</u> <u>(15)</u>		
5.0	BRAKE NC	NC BRAKE
 		
<b>Comment:</b> NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT		

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 43229

Part Number: D35647

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/11/14 (15)

08/11/14 (X15)

7.0 POWDER COATING

POWDER COATING



M 10 6442



(15X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45  
320 OF  
1:15

MF 08/11/18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/11/18 (15)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-19

FZ 08/11/18 (15)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

Job Completion



MF 08-11-18

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43239
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3564-7
<b>Inspection Dwg:</b> D3564	<b>Rev:</b> C	<b>Page 1 of 1</b>

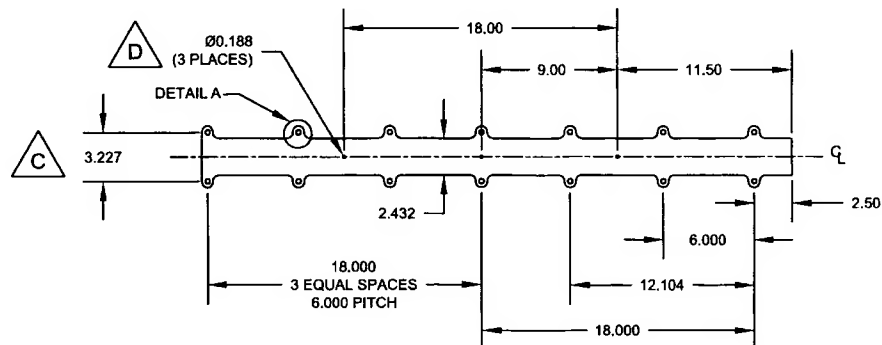
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

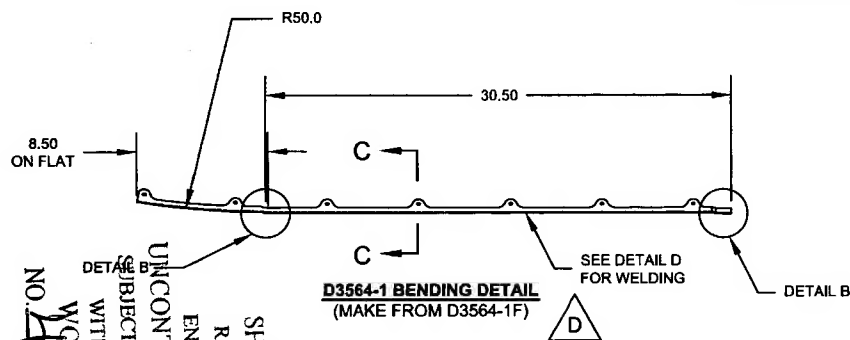
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225	X			
2.432	+/-0.010	2.429	X			
28.50	+/-0.030	28.50	X			
23.500	+/-0.010	23.500	X			
9.25	+/-0.030	9.254	X			
10.00	+/-0.030	9.996	X			
5.875	+/-0.010	5.875	X			
0.300 x 0.300	+/-0.010	304 x 306	X			
Ø0.188	+0.005/-0.001	193	X			
R0.375	+/-0.010	375	X			
0.063	+/-0.010	1059	X			

<b>Measured by:</b> PB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-11-11	<b>Date:</b> 66-11-12	<b>Date:</b>	N/A

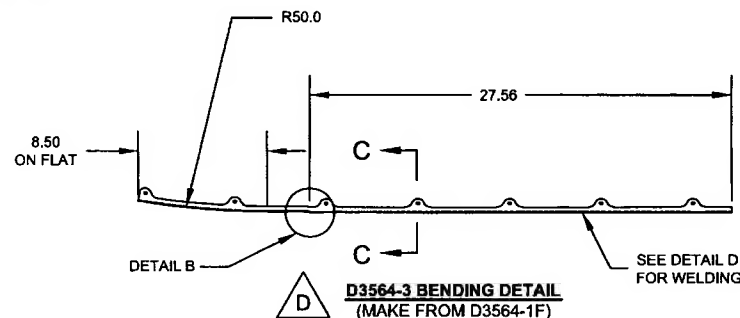
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM [Signature]	[Signature]



**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

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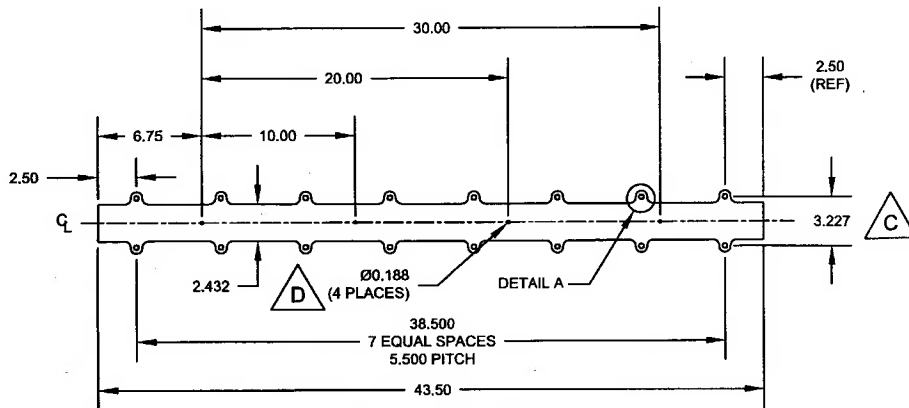
**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

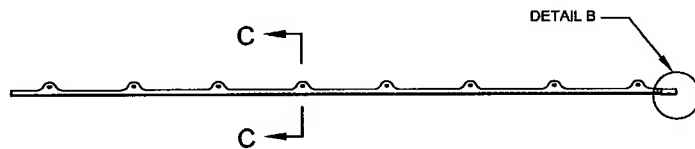
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
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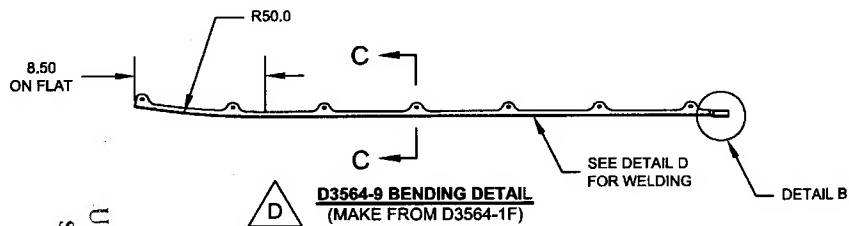
8 7 6 5 4 3 2 1



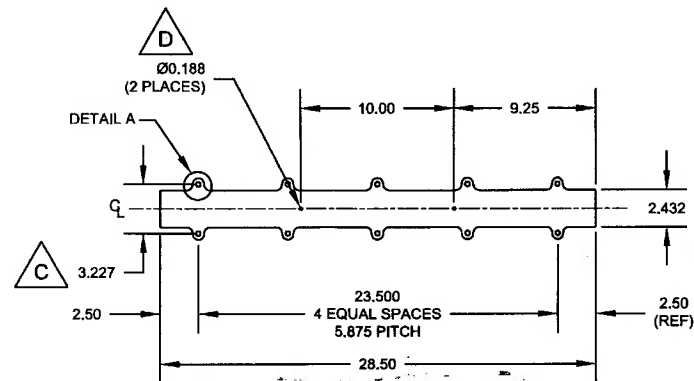
**D3564-5F FLAT PATTERN**



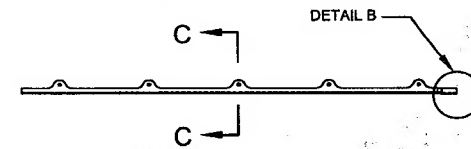
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



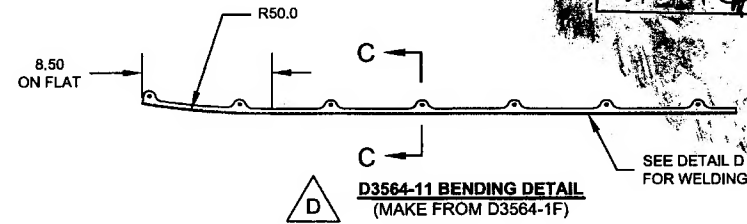
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED

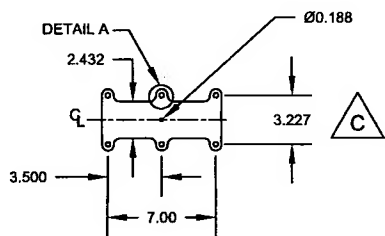
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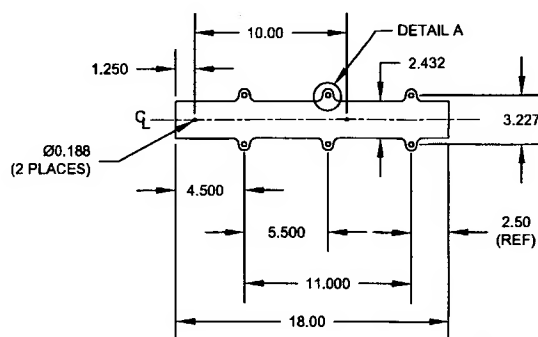
DESIGN	PH	<b>DART AEROSPACE LTD</b>	
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8 7 6 5 4 3 2 1

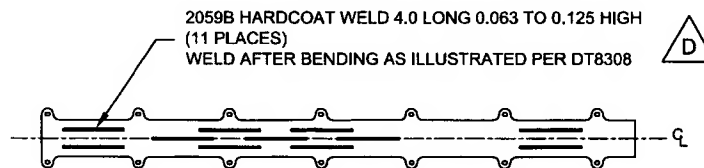
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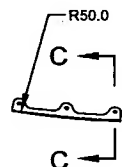
**D3564-13F FLAT PATTERN**



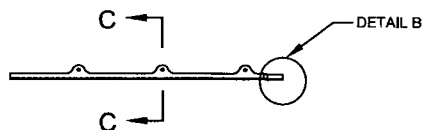
**D3564-15F FLAT PATTERN**



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)



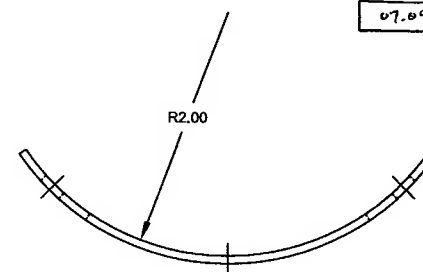
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



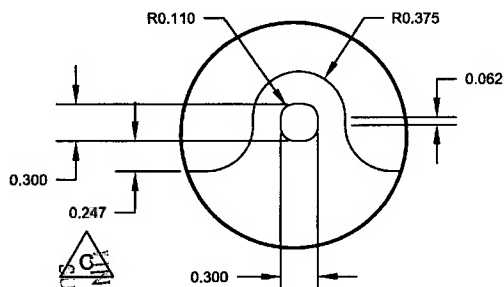
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

**RELEASED**

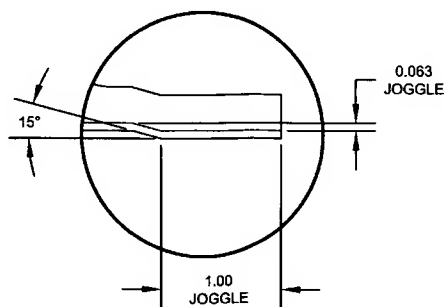
07.09.04



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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